

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (Currently amended) Method for dynamic adjustment of roller segments (13 to 17) that support and/or guide both sides of a continuously cast strand (4) made of metal, with at least two successive pairs of rollers (18), comprising the steps of: adjusting the pairs of rollers (18) relative to each other with piston-cylinder units (19), which are acted upon with both position control and pressure control; subsequently adjusting the pairs of rollers (18) to the continuously cast strand (4) by position control; switching hydraulic pressure from position-controlled operation to pressure-controlled operation when the hydraulic pressure in a piston-cylinder unit (19) reaches a predetermined value; installing the roller segments (13 to 17) in a hot bar zone and a soft reduction zone; and operating the roller segments by an automatic segment control system (32) and a basic automation system (33) so that the method is

applied to roller segments (13 to 17) of continuous bloom and billet casting machines (20) , wherein in the soft reduction zone the rollers are operated on the billet while the billet is in a semi-solid state, further including installing rotationally driven rollers (23) on the segment entrance side (21) and/or on the segment exit side (22), wherein the driven rollers are driven by drive motors in communication with the basic automation system.

2. (Previously presented) Method in accordance with Claim 1, further including switching integrated, driven rollers (23) arranged on the segment entrance side (21) and/or on the segment exit side (22) of swiveling and/or parallel-adjustable roller segments (13 to 17) from position-controlled operation to pressure-controlled operation, depending on the phase of the process.
3. (Currently amended) Continuous casting device for casting continuous bloom or billet sections, with a containment roll stand (5), which is arranged after a continuous casting mold (2), and with a bending-straightening unit (11), wherein a device is arranged at least partially in front of the bending-straightening unit (11) or completely

behind the bending-straightening unit (11), with several hydraulically operated piston-cylinder units (19) with position-controlled or pressure-controlled, adjustable roller segments (13 to 17), each of which has at least one rotationally driven roller (23), wherein the rollers are operated on the billet while the billet is in a semi-solid state, wherein the rotationally driven rollers (23) are installed on the segment entrance side (21) and/or on the segment exit side (22), wherein a drive motor (29) is provided to drive one of the driven rollers (23), and wherein a basic automation system (33) is in communication with the drive motor (29).

4. (Canceled).
5. (Previously presented) Continuous casting device in accordance with Claim 3, wherein a drive motor (29) for a driven roller (23) is arranged, together with a transfer case (30), on one side (26) of the segment frame (27) with a vertical drive shaft orientation (28).
6. (Previously presented) Continuous casting device in accordance with Claim 3, wherein an adjustment and

automatic control concept (31) for dynamic adjustment is divided into an automatic segment control system (32) and a basic automation system (33).

7. (Previously presented) Continuous casting device in accordance with Claim 6, wherein the automatic segment control system (32) comprises at least a given operation strategy (34, 39, 40), roll spring compensation (35), a maximum force regulator (36), a minimum force regulator (37), and a positioning system (38).
8. (Previously presented) Continuous casting device in accordance with Claim 6, wherein the basic automation system (33) comprises at least a given type of operation (34), a torque controller (39) and a speed controller (40).
9. (Previously presented) Continuous casting device in accordance Claim 3, wherein two pressure sensors (41) spaced some distance apart for different piston positions and a position sensor (42) for a piston (43) of a piston-cylinder unit (19) are provided on each piston-cylinder

unit (19) and are connected with the automatic segment control system (32).

10. (Previously presented) Continuous casting device in accordance with Claim 3, wherein a drive motor (29) for the driven roller (23) communicates with a basic automation system (33).